

# Work Order ID 117308

June-16-14 10:54:37 AM

**\*117308\***

Page 1

Item ID: D4805-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: End Fitting  
 Start Date: 6/16/14 Start Qty: 2.00 \*?  
 Required Date: 6/16/14 Req'd Qty: 2.00 \*?  
 Reference: PART MARKING Cust Item ID:  
 Customer:

Approvals: Process Plan: W Date: 1406-16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4805	REV A								

105 0.00  
**\*105\***  
 Purchasing  
 Purchasing

Memo  
 PULL FROM STK:  
 2 X D4805-5 B112024 ✓  
 SEND TO P & L PRINTING FOR PART MARKING  
 PO 24622

108 0.00  
**\*108\***  
 Packaging  
 Packaging

Receive & Inspect for Damage & Mat'l Certs  
 Memo 0.00

110 0.00  
**\*110\***  
 QC  
 Quality Control

QC6- Inspect dimensions to drawing  
 Memo 0.00

N/A  
 already engraved  
 on Haas

C2 14/06/17

14/5/12

Work Order ID 117308

\*117308\*

Page 2

June-16-14 10:54:38 AM

Item ID: D4805-5 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: End Fitting  
 Start Date: 6/16/14 Start Qty: 2.00 \*2\* Cust Item ID:  
 Required Date: 6/16/14 Req'd Qty: 2.00 \*2\* Customer:  
 Reference: PART MARKING

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
115	Identify as per dwg & Stock Location: _____	0.00							
<b>*115*</b>									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B.N								
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

h 440626  
 J

# Picklist Print

June-16-14 10:54:37 AM

Page 1

Work Order ID: 117308

**\*117308\***

Parent Item: D4805-5

**\*D4805-5\***

Parent Item Name: End Fitting

Start Date: 6/16/14

Required Date: 6/16/14

Start Qty: 2.00

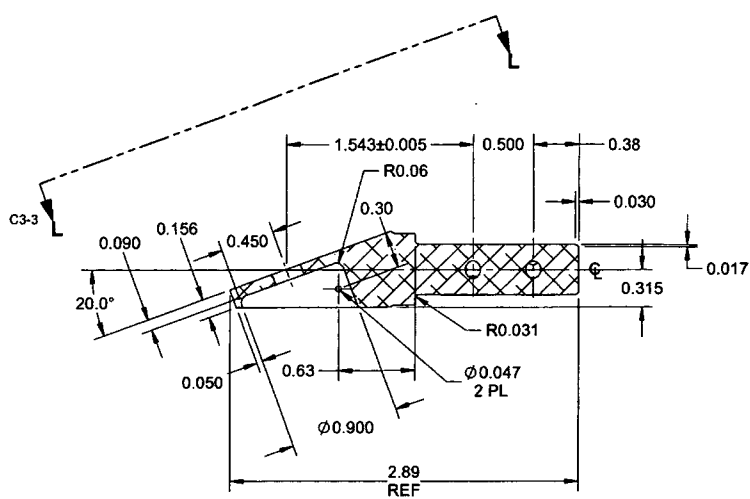
Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE JLM 14-01-28 VERIFIED BY:JFS

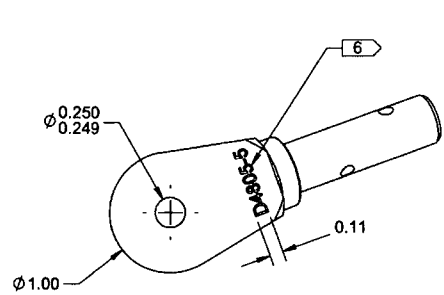
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4805-5		Manufactured	No				Each	0.0000		2			
<b>*D4805-5*</b>									<b>**</b>				
End Fitting													

*16/16/14 E*

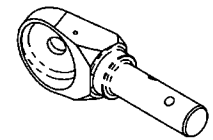
8 7 6 5 4 3 2 1



**SECTION I-I** B7-3

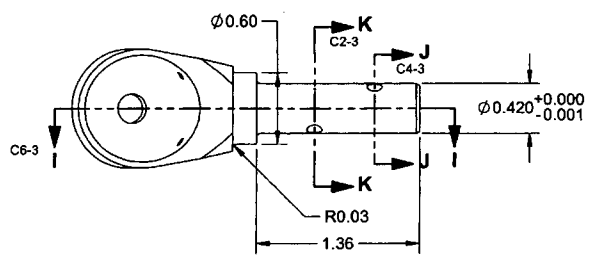


**AUXILIARY VIEW L-L** D8-3

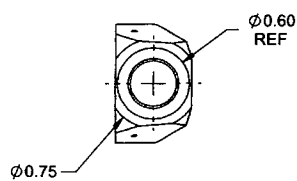


SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 117308 MLJ

1406-16



**SECTION J-J** B6-3



**SECTION K-K** B6-3

**D4805-5 END FITTING**

- NOTES:**
- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION  
PER AMS 5643/ASTM A564  
DART SPEC M17-4-R
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3.  
ENGRAVE P/N USING 0.11 HIGH LETTERS TO A MAX. DEPTH OF 0.010
  - 7) WEIGHT: 0.14 lbs
  - 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED	DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	HS	DRAWING NO.	REV. A
	MFG. APPR.	JLM	<b>D4805</b>	SHEET 3 OF 3
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	<b>END FITTING</b>	NTS
DATE		13.12.16	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1